

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021612**Date Inspected:** 02-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Geng Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

BAY#14

East Side

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 08427

Ultrasonic Testing (UT)

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as OBG Component. The weld designation reviewed as follows:

SEGMENT 13CE

SEG3007AH – 083; 082

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint #020 located on 13AE, SA3007AH. Welder is identified as 068917. ZPMC Quality Control (QC)

Inspector is identified as Liu Hui Jie. The welding variables recorded by QC appeared to comply with the

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WPS-B-P-2214-Tc-U4b-FCM-1.

Weld joint #026 located on 13AE, SA3007AH. Welder is identified as 068097. ZPMC Quality Control (QC) Inspector is identified as Liu Hui Jie. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

Weld joint #029 located on 13AE, SA3007AH. Welder is identified as 068917. ZPMC Quality Control (QC) Inspector is identified as Liu Hui Jie. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-Tc-U4b-FCM-1.

Flux Cored Arc Welding (FCAW):

Weld joint #014 located on 13AE, saddle support beam SA3066-001. Welder is identified as 044795. ZPMC Quality Control (QC) Inspector is identified as Liu Hui Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #003 located on 13BE, SEG3009C. Welder is identified as 066041. ZPMC Quality Control (QC) Inspector is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #019 located on 13AE, saddle support beam SA3067-001. Welder is identified as 214945. ZPMC Quality Control (QC) Inspector is identified as Liu Hui Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132-ESAB. (See attached photo)

Weld joint #032 located on 13AE, SA3007AH. Welder is identified as 067877. ZPMC Quality Control (QC) Inspector is identified as Liu Hui Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #002 located on 13BE, SEG3009J. Welder is identified as 206623. ZPMC Quality Control (QC) Inspector is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #016 located on 13AE, saddle support beam SA3066-001. Welder is identified as 055491. ZPMC Quality Control (QC) Inspector is identified as Liu Hui Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-ESAB.

Weld joint #002 located on 13CE, SA3214A-001. Welder is identified as 037705. ZPMC Quality Control (QC) Inspector is identified as Zhong Yong Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

Weld joint #019 located on 13AE, SA3007AH. Welder is identified as 066163. ZPMC Quality Control (QC) Inspector is identified as Liu Hui Jie. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-ESAB.

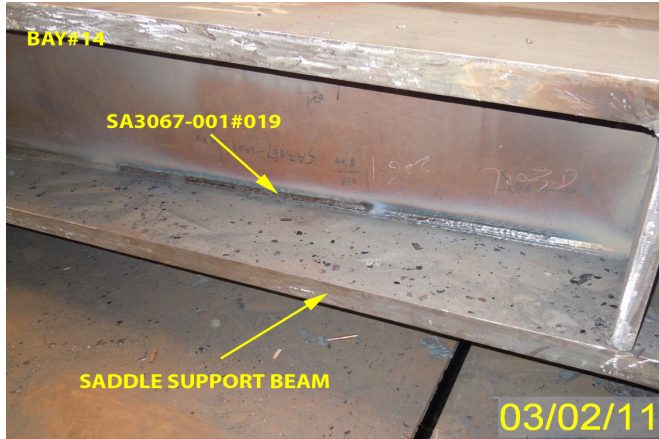
Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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### Summary of Conversations:

No Relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Patterson,Rodney	QA Reviewer

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